

Work Order ID 62369

Tuesday, September 28, 2010 11:49:44 AM

Page 1

Item ID: PB67-43001-17

Accept

Revision ID:

Item Name: Aft Adjustable Blade Support Assembly

Start Date: 9/29/2010 Start Qty: 1.00

Required Date: 10/6/2010 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: *UMF*

Date: *10-9-28*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

B67-43001-17

Rev C

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- make a 0.090" chamfer in the 1.00" hole before welding □ 2- assemble parts and weld as per dwg

10.10.04 1

110

~~QC9-Inspect visual per QSI004- Fusion Welds~~

0.00



QC

Memo

0.00

Quality Control

N/A

120

~~QC5-Inspect part completeness to step on W/O~~

0.00



QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
105 <i>E</i> <i>10.10.04</i>	Small Fab <i>Log Fab.</i>	0.00							
Small Fab	Memo	0.00							
Small Fab	1- grind weld flush in area of PB67-43001-249 only □ 2- install helicol insert as per dwg								
140	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
150	Chemical Conversion Coat per QS1005 4.1	0.00							
HandFinish	Memo	0.00							
Hand Finishing									

QCA -> PD 10.10.05

QCS => 8/21/06 *(X)*

N/A E

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Cust Item ID:

Required Date: 10/6/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 Powdercoat Powder Coating	Green Sandtex(Ref:4.3.5.8) per QSI005 4.3 M18144 Memo 1- MASK TUBE FROM BASE TO GUSSET START TIME: 1:40 <input type="checkbox"/> OVEN TEMPERATURE: 320° <input type="checkbox"/> FINISH TIME: 2:10	0.00 0.00		10-10-6		1			
170 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00		=> 10/10/11		1			
180 Small Fab Small Fab Small Fab	Small Fab Memo 1- match drill cover to existing holes in support <input type="checkbox"/> 2- assemble as per dwg	0.00 0.00		10.10.14		1			

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Setup Start



Revision ID:

Stop



Item Name: Aft Adjustable Blade Support Assembly

Start Date: 9/29/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/6/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

10.10.14



Quality Control

200

Identify as per dwg & Stock Location: WPA

0.00



Packaging

Memo

0.00

10.10.14

1

9

Packaging

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

10/10/14

MF
10-10-14

Quality Control

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 1

Work Order ID: 62369

Parent Item: PB67-43001-17

Parent Item Name: Aft Adjustable Blade Support Assembly

Start Date: 9/29/2010


Required Date: 10/6/2010

Start Qty: 1.00

Required Qty: 1.00


Comments: IPP Rev:A 08-06-26 new issue DD verified by:ec
10.09.28 per rev C dwg EC verified by:DD

IPP Rev B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS124780  HELICAL INSERT		Purchased	No			180	Each	142.0000	1	1		10.10.04	


Location Loc Qty Loc Code


ST314 142
111064 142

MS27039-1-10  Screw		Purchased	No			180	Each	117.0000	8	8		10.10.14	
---	--	-----------	----	--	--	-----	------	----------	---	---	--	----------	--

Location Loc Qty Loc Code

ST291 117
112794 17
112940 100

NAS1149D0316J /AN98SP10LL  Washer		Purchased	No			180	Each	0.0000	8	8		10.10.14 B19600	
---	--	-----------	----	--	--	-----	------	--------	---	---	--	-----------------	--

NAS1149D0363J  Washer		Purchased	No			180	Each	2,907.000	8	8		10.10.14	
---	--	-----------	----	--	--	-----	------	-----------	---	---	--	----------	--

Location Loc Qty Loc Code

ST298 2907
114292 114
114884 41
115107 27
115622 2716
9221 9

W/O:		WORK ORDER CHANGES					
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Work Order ID: 62369

Parent Item: PB67-43001-17

Parent Item Name: Aft Adjustable Blade Support Assembly

Start Date: 9/29/2010

Required Date: 10/6/2010

Start Qty: 1.00

Required Qty: 1.00

PB67-43001-249 Manufactured No
Inner Tube Bushing

100 Each

11.0000

1

1

Location

Loc Qty

Loc Code

ST438

11

52480

11

PB67-43001-253 Manufactured No
Gusset

100 Each

4.0000

1

1

Location

Loc Qty

Loc Code

ST438

4

44983

4

PB67-43001-254 Manufactured No
Gusset

100 Each

24.0000

1

1

Location

Loc Qty

Loc Code

ST438

24

52481

24

PB67-43001-259 Manufactured No
Inner Tube

100 Each

3.0000

1

1

Location

Loc Qty

Loc Code

ST446

3

43069

1

44979

2

PB67-43001-71 Manufactured No
PB67-43001-71

130 Each

3.0000

1

1

Location

Loc Qty

Loc Code

ST437A

3

41512

3

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 3

Work Order ID: 62369



Parent Item: PB67-43001-17



Parent Item Name: Aft Adjustable Blade Support Assembly

Start Date: 9/29/2010

Required Date: 10/6/2010

Start Qty: 1.00

Required Qty: 1.00

PB67-43001-73

Manufactured No

180

Each

2.0000

1

1



20 Degree Cover Plate



10.10.14

Location

Loc Qty

Loc Code

ST445

2

41513

2

PB67-43001-83

Manufactured No

180

Each

6.0000

1

1



PB67-43001-83



10.10.14

Location

Loc Qty

Loc Code

ST445

6

52418

6

1

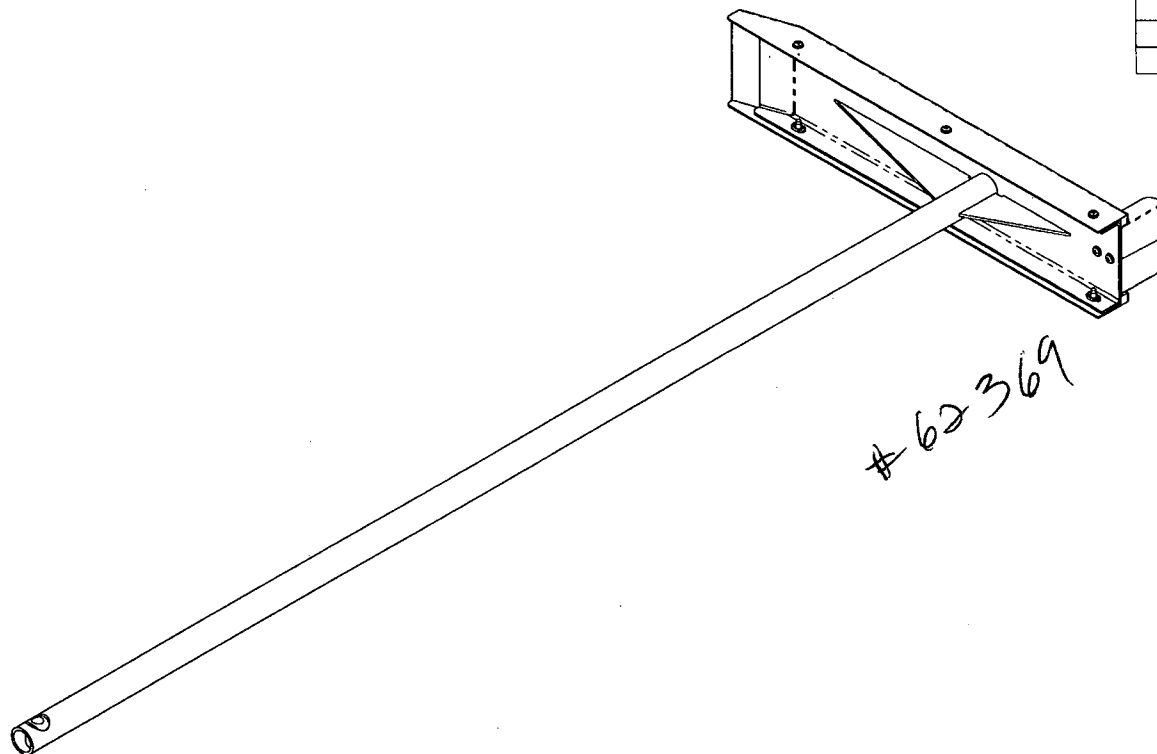
W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

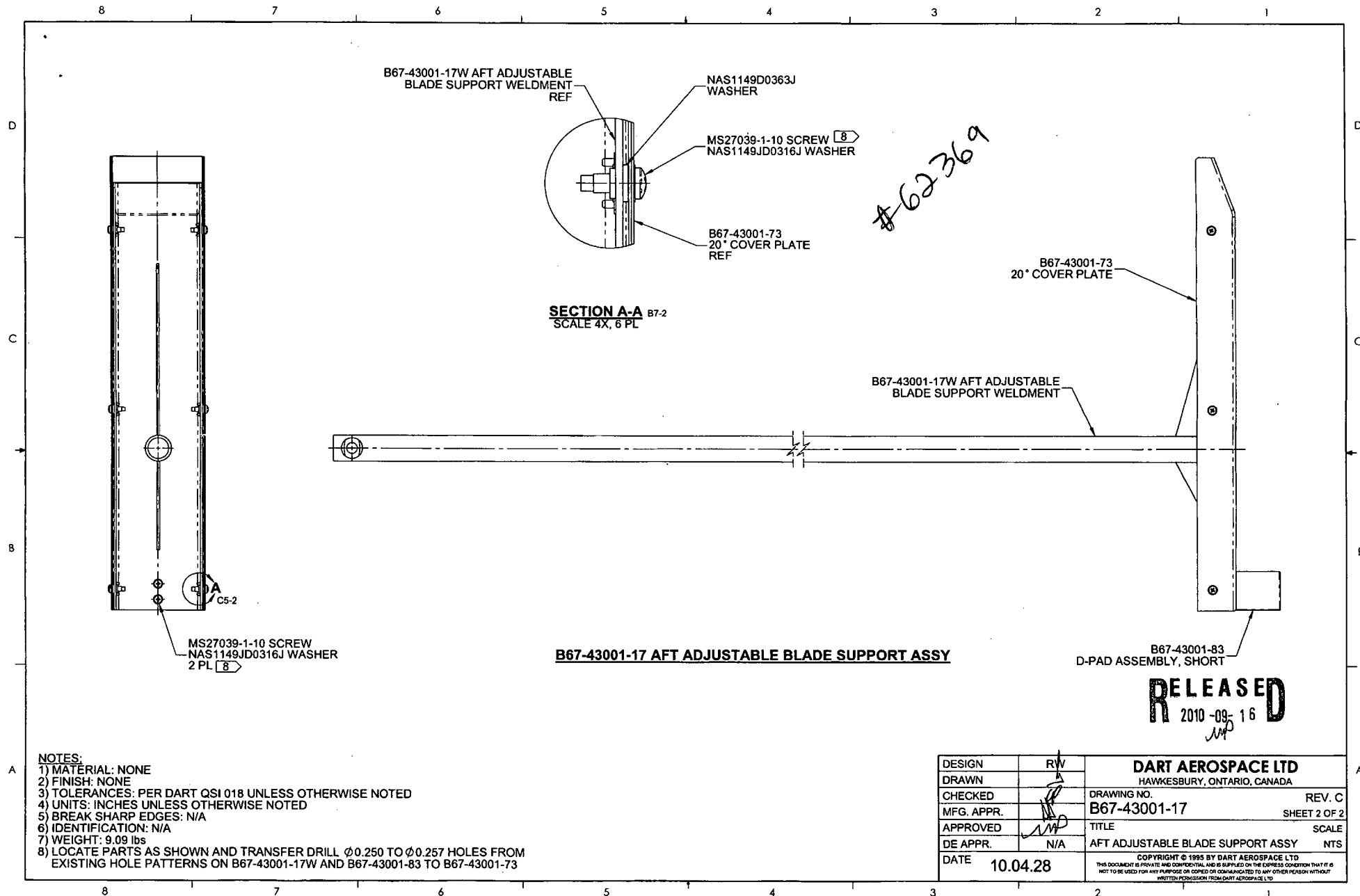


B67-43001-17 AFT ADJUSTABLE BLADE SUPPORT ASSY

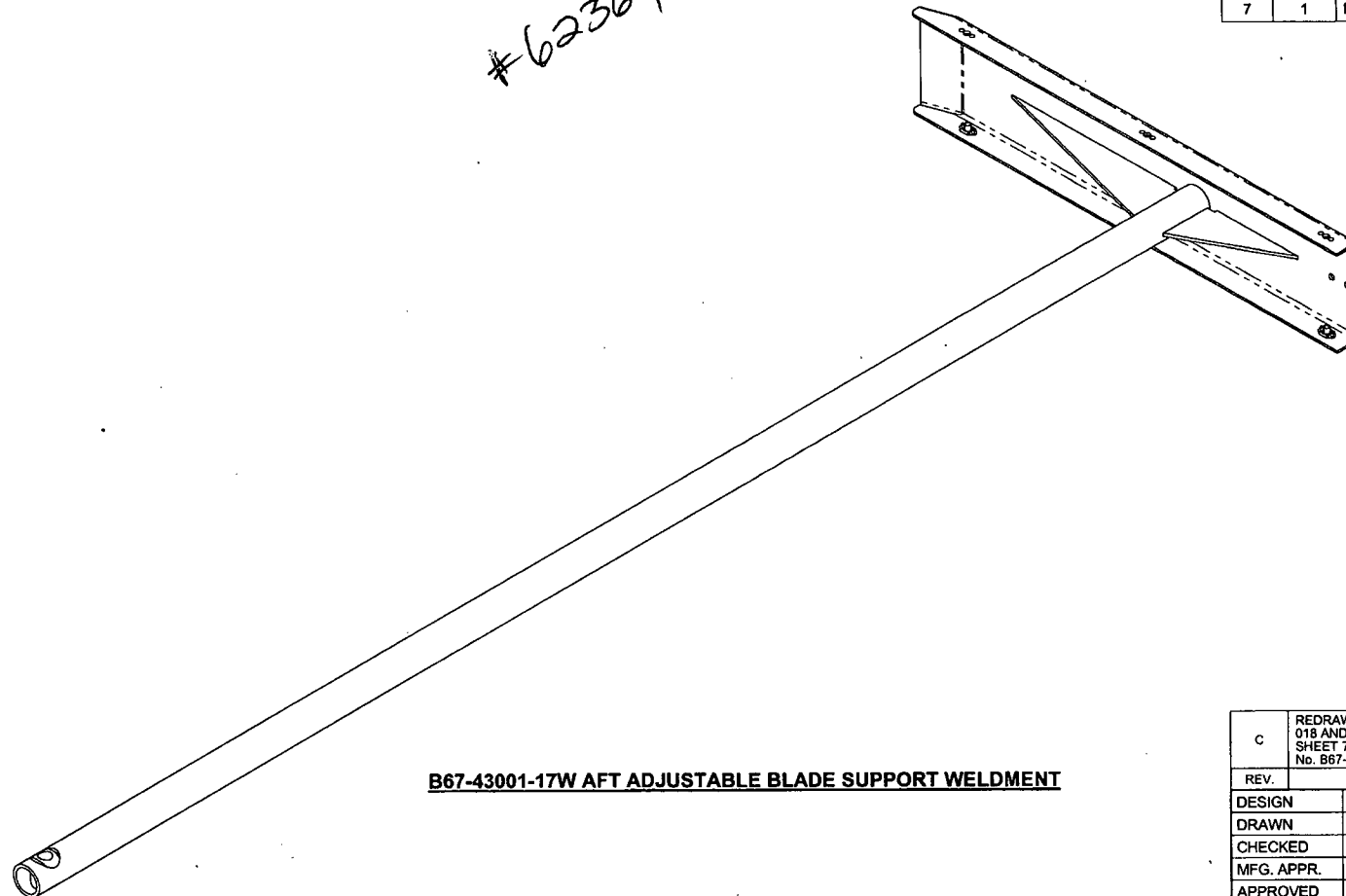
ITEM	QTY -17	P/N	DESCRIPTION
1	X	B67-43001-17	AFT ADJUSTABLE BLADE SUPPORT ASSEMBLY
2	1	B67-43001-17W	AFT ADJUSTABLE BLADE SUPPORT WELDMENT
3	1	B67-43001-73	20" COVER PLATE
4	1	B67-43001-83	SHORT D-PAD ASSY
5	8	MS27039-1-10	SCREW
6	8	NAS1149D0316J	WASHER
7	6	NAS1149D0363J	WASHER

RELEASED
2010-09-16
mb

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 7 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	10.04.28
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. B67-43001-17 REV. C SHEET 1 OF 2 TITLE AFT ADJUSTABLE BLADE SUPPORT ASSY SCALE NTS		
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED		DATE 10.04.28		
DE APPR.	N/A	<small>COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		



#62369



B67-43001-17W AFT ADJUSTABLE BLADE SUPPORT WELDMENT

ITEM	QTY -17W	P/N	DESCRIPTION
1	X	B67-43001-17W	AFT ADJUSTABLE BLADE SUPPORT WELDMENT
2	1	B67-43001-71	20-DEGREE BLADE SUPPORT ASSY
3	1	B67-43001-249	INNER TUBE BUSHING
4	1	B67-43001-253	GUSSET
5	1	B67-43001-254	GUSSET
6	1	B67-43001-259	INNER TUBE
7	1	MS124780	HELICAL INSERT

RELEASED
2010-09-16

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 7 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.	MB	10.04.28
REV.	DESCRIPTION	BY	DATE
DESIGN	RW	DART AEROSPACE LTD	
DRAWN	J	HAWKESBURY, ONTARIO, CANADA	
CHECKED	J	DRAWING NO.	REV. C
MFG. APPR.	J	B67-43001-17W	SHEET 1 OF 2
APPROVED	J	TITLE	SCALE
DE APPR.	N/A	AFT ADJUSTABLE BLADE SUPPORT WELDMENT	NTS
DATE	10.04.28	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

